

Work Order ID 66715

Thursday, February 24, 2011 11:39:38 AM



Page 1

Item ID: D3281-3L02

Accept



Setup Start



Revision ID:

Item Name: Floor Protector, Aft LH (Black)

Stop



Start Date: 2/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: HDate: 1/02/24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3281	Rev E
DSI 9504	A

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

x4

Dh
11/03/02

Thermoforming Machine

Cut Blanks

105

0.00



Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

x4

Dh
11/03/02Temp: 240°FTime IN: 4:00 pm

11/03/01

Time OUT: 7:00 am

11/03/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Run Start

**QC:****Date:****SPC (Y/N):****Date:**

Stop

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

110



THERMOFORMING MACHINE

0.00

x4

SL

Thermoform

Thermoforming Machine

Memo

0.00

Thermoform as per Dwg. D3281 and Folio FTA 009
Dwg. Rev. F
Folio Rev. J

11/03/02

120



QC2- Inspect parts off machine FAI/FAIB

0.00

x4

SL

QC

Quality Control

Memo

0.00

11/03/02

130



HAND FINISHING THERMOFORMING

0.00

x4

SL

Thermoform

Thermoforming Machine

Memo

0.00

Trim to Finished Dimensions

10/03/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Item ID: D3281-3L02

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Item Name: Floor Protector, Aft LH (Black)

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Start Date: 2/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

140



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

84

W6

2/03/07

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 1103/08

④

160



Packaging

Packaging

Packaging

Memo

0.00

0.00

113/958

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 4

Item ID: D3281-3L02

Accept



Setup Start



Revision ID:

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Start Date: 2/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberReject
NumberInsp.
Stamp

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/9 *J*
R 11-03-9
(H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Thursday, February 24, 2011 11:39:45 AM

Page 1

Work Order ID: 66715



Parent Item: D3281-3L02



Parent Item Name: Floor Protector, Aft LH (Black)

Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 04.07.01 New issue KJ/JLM

IPP Rev B 07.08.07 Thermoform in house DL

Add Step 105 Dry Material 10/04/21 DL

IPP Rev. C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-02		Purchased	No				sf	744.3100		17.332			

GE PLASTICS LEXAN SHEET



Location

therm

110877

Loc Qty

744.31

Loc Code

744.31

11/03/07

17.332 sf ft

W/O:		WORK ORDER CHANGES					
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D044-719 REV. A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D044-719 REV. 0

REF TCCA STC: SH04-40

REF FAA STC: SR02051NY

REF EASA STC: EASA.IM.R.S.01075

PURPOSE:

To add the D044-719-011L08 Clear Cabin Floor Protectors. The -011L08 kit is similar to the existing -011 kit, however the plastic is transparent instead of solid black. The existing D044-719-011 kit will be re-identified as D044-719-011L02.

CHANGE:

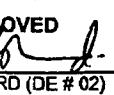
The D044-719-011L08 Cabin Floor Protectors kit consists of four transparent plastic trays that are placed on the cabin floor to protect the carpets from damage. The -011L08 kit should be installed per the -011 kit of Installation Instructions IIN-D044-719 and maintained per Instructions for Continued Airworthiness ICA-D044-719. The parts list and weight & balance for the -011L08 kit is given below.

PARTS LIST

QTY -011L02	QTY -011L08	Part Number	Description
X		D044-719-011L02	Cabin Floor Protectors (Black)
	X	D044-719-011L08	Cabin Floor Protectors (Clear)
1		D3281-1L02	Floor Protector, Fwd LH, Black
	1	D3281-1L08	Floor Protector, Fwd LH, Clear
1		D3281-2L02	Floor Protector, Fwd RH, Black
	1	D3281-2L08	Floor Protector, Fwd RH, Clear
1		D3281-3L02	Floor Protector, Aft LH, Black
	1	D3281-3L08	Floor Protector, Aft LH, Clear
1		D3281-4L02	Floor Protector, Aft RH, Black
	1	D3281-4L08	Floor Protector, Aft RH, Clear
8	8	D2854-1-100	Looped Velcro Strip
8	8	D2854-3-100	Hooked Velcro Strip

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D044-719-011L02 Cabin Floor Protectors	3.9 lb 1.8 kg	0 in 0 m	0 in-lb 0 m-kg	50 in 1.27 m	195 in-lb 2.3 m-kg
D044-719-011L08 Cabin Floor Protectors	4.4 lb 2.0 kg	0 in 0 m	0 in-lb 0 m-kg	50 in 1.27 m	220 in-lb 2.5 m-kg

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-0-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	10.02.24
CERT. NO.:	SH04-40
ISSUE NO.:	1

A	NEW ISSUE		CP	10.02.24
REV.	DESCRIPTION		BY	DATE
DESIGN		#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		#		
CHECKED		X	REV. A DRAWING NO. DSI 9504 SHEET 1 OF 1	
MFG. APPR.		N/A		
APPROVED		#	TITLE FLOOR PROTECTOR KIT, CLEAR SCALE NTS	
DE APPR.		#		
DATE		10.02.24	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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 WITHOUT NOTICE
 WORK ORDER
 NO. 66715
PT 11-02-24

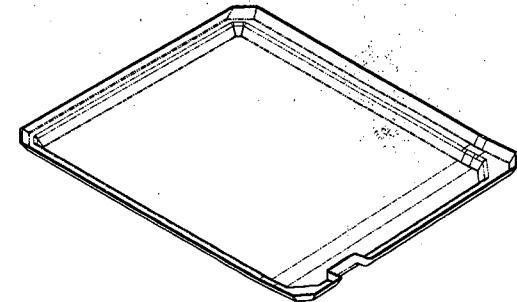
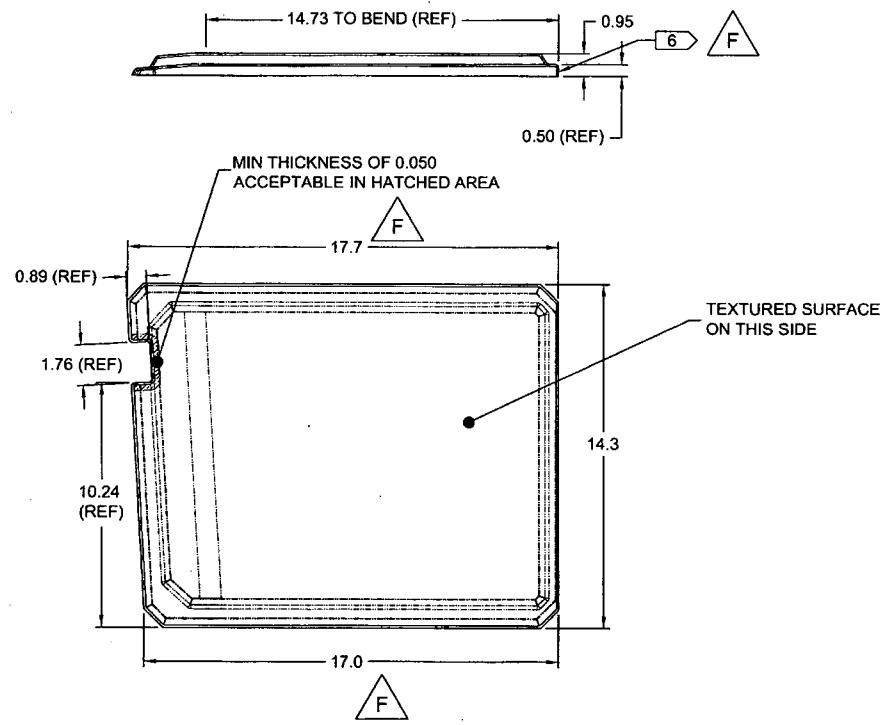
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WORK ORDER
NO. 16715

PL11-02-24

RELEASED
2010-11-25 14

NOTES:

- 1) MATERIAL: -3L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-3L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENT WITH DART P/N "D3281-3Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN
- 7) WEIGHT: D3281-3L02 = 0.87 lb D3281-3L08 = 1.05 lb
- 8) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

DESIGN	97	DART AEROSPACE LTD		
DRAWN	8	HAWKESBURY, ONTARIO, CANADA		
CHECKED	99	DRAWING NO.	REV. F	
MFG. APPR.	99	D3281	SHEET 3 OF 4	
APPROVED	99	TITLE	SCALE	
DE APPR.	99	FLOOR PROTECTOR		
DATE	10.09.27	NTS		

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DART AEROSPACE LTD	Work Order:	66715
Description: Floor Protector, Aft LH	Part Number:	D3281-3
Inspection Dwg: D3281 Rev: E E Dc		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by

Date: _____

11/03/02

TRIMMING SECTION

Measured by:

Date:

11/03/07

Audited by:

Date:

11/03/08

Preliminary Approval:

N/A

Date:

114

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL	
D	10.09.01	Dimensions updated per Dwg Rev E	KJ	94